

Work Order ID 80513

February-22-12 11:18:44 AM

80513

Page 1

Item ID: D206-667-101TRN

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Turning Detail

Start Date: 22/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M.C.TDate: 12/02/22 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D206-667-141

Rev C

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA083

2-Turn first side as per Folio FA083

3-Blend transition lines only, **do not sand whole tube**:

FOLIO REV: AHDWG REV: C

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

1 Ømm.l 12/02/23

110

QC1- Inspect dimensions to dimension sheet

0.00

110

QC

Memo

0.00

Quality Control

1 Ømm.l 12/02/23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | MORI SEIKI CNC LATHE LARGE | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| Mori Seiki | Memo | 0.00 | | | | | | | |
| Mori Seiki CNC Lathe Large | 1-Turn second side as per Folio FA083 | | | | | | | | |
| | 2-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit. FOLIO REV: <u>AA</u> DWG REV: <u>C</u> | | | | | | | | |
| | 3-Remove sand and plugs | | | | | | | | |
| 130 | QC1- Inspect dimensions to dimension sheet | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

man L 12/02/22

man L 12/02/22

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Start Date: 22/02/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 07/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control



12-2-25

145

0.00

145

Crosstubes

Memo

0.00

Crosstubes

GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.



12-2-26

150

Crosstubes Chemical Conversion

0.00

150

HandFXtube

Memo

0.00

Hand Finishing Crosstubes



12-2-26

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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N900040100

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Revision ID:

Item Name: Crosstube Turning Detail

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Start Date: 22/02/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 07/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | Packaging | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and stock in kanban rack Location: | <u>L/G</u> | | | | | | | |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

Handwritten: 12 02 2012

Handwritten: 1 0 12/02/27

Handwritten: 12/2/27

Handwritten: 12-02-11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

February-22-12 11:18:48 AM

Page 1

Work Order ID: 80513

80513

Parent Item: D206-667-101TRN

D206-667-101TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 22/02/2012

Required Date: 07/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 remove polish EC verified by: DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6001-105 | | Manufactured | No | | | 110 | Each | 26.0000 | 1 | 1 | | | |

D6001-105

Crosstube, Material

Location

Loc Qty

Loc Code

LG

26

25661

3

29115

23

1 mm.c 12/02/02

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

| | | |
|--|--|----------------------------------|
| DART AEROSPACE LTD | | Work Order: 80513 |
| Description: Crosstube Assembly (206B High Fwd) | | Part Number: D206-667-141 |
| Inspection Dwg: D206-667-141 Rev: C | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet | Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| SIDE A | 2.240 | +0.005/-0.000 | 2.242 | / | | vern | CNC-08 |
| | 2.074 | +0.005/-0.000 | 2.078 | / | | | |
| | 2.074 | +0.005/-0.000 | 2.079 | / | | | |
| | 2.114 | +0.005/-0.000 | 2.117 | / | | | |
| | 2.154 | +0.005/-0.000 | 2.155 | / | | | |
| | 2.194 | +0.005/-0.000 | 2.198 | / | | | |
| | 2.234 | +0.005/-0.000 | 2.239 | / | | | |
| | | | | | | | |
| | 0.110 | +/-0.010 | .110 | / | | vern | CNC-08 |
| | 0.300 x 30° | +/-0.010 | .300 x 30° | / | | " | |
| SIDE B | R0.063 | +/-0.010 | .063 | / | | RC | |
| | R0.500 | +/-0.010 | .500 | / | | " | |
| | 4.438 | +/-0.030 | 4.440 | / | | vern | CNC-08 |
| | | | | | | | |
| | 2.240 | +0.005/-0.000 | 2.243 | / | | vern | CNC-08 |
| | 2.074 | +0.005/-0.000 | 2.079 | / | | | |
| | 2.074 | +0.005/-0.000 | 2.079 | / | | | |
| | 2.114 | +0.005/-0.000 | 2.117 | / | | | |
| | 2.154 | +0.005/-0.000 | 2.156 | / | | | |
| | 2.194 | +0.005/-0.000 | 2.198 | / | | | |
| | 2.234 | +0.005/-0.000 | 2.239 | / | | | |
| | | | | | | | |
| | 0.110 | +/-0.010 | .110 | / | | vern | CNC-08 |
| | 0.300 x 30° | +/-0.010 | .300 x 30° | / | | " | |
| | R0.063 | +/-0.010 | .063 | / | | RC | |
| | R0.500 | +/-0.010 | .500 | / | | " | |
| | 4.438 | +/-0.030 | 4.438 | / | | vern | CNC-08 |
| | | | | | | | |
| | 93.18 | +/-0.020 | 93.160 | / | | tape | MM. 702 |
| | | | | | | | |

| | | | |
|---------------------------|--------------------------------|----------------------------|-----|
| Measured by: MAM L | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 12/02/22 | Date: 12-2-25 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|-------------|
| A | 06.10.24 | New Issue (P/O D206-667-101) | KJ/JLM | |
| B | 09.12.14 | Dwg Rev updated | KJ | [Signature] |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

| Item | Qty -141 | Part Number | Description |
|------|-------------|----------------|--|
| 1 | X | D206-667-141 | CROSSTUBE ASSEMBLY (206B HIGH FWD) |
| 2 | 1 | D6001-105 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2891-1 | SUPPORT |
| 6 | 4 | D3595-063-395 | RUBBER CUSHION |
| 7 | 4 | MS21920-20 | CLAMP (OR MS21920-21) |
| 8 | 14 | MS20601AD4W8 | RIVET (OR NAS9302B-4-8) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 93.18±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-141" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 11.3 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SIR
F.
E.
UNCOM
SUBJECT

DEO ATTACHED

NO. 80513 M.L.J
12/02/22
OCW #11-615
11.07.26

UNDER REVIEW

RELEASED
08/11/12/14

| | | | |
|--|--|----|----------|
| C | REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C4-3, C5-3 & D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. | RF | 08.11.08 |
| B | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES | PH | 05.07.26 |
| A | NEW ISSUE | CP | 00.11.17 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 9 | | |
| DRAWN | RF | | |
| CHECKED | 10 | | |
| MFG. APPR. | 11 | | |
| DE APPR. | 12 | | |
| DATE | 08.11.06 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D206-667-141 TITLE CROSSTUBE ASSY (206B HIGH FWD) SCALE NTS REV. C SHEET 1 OF 4 COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

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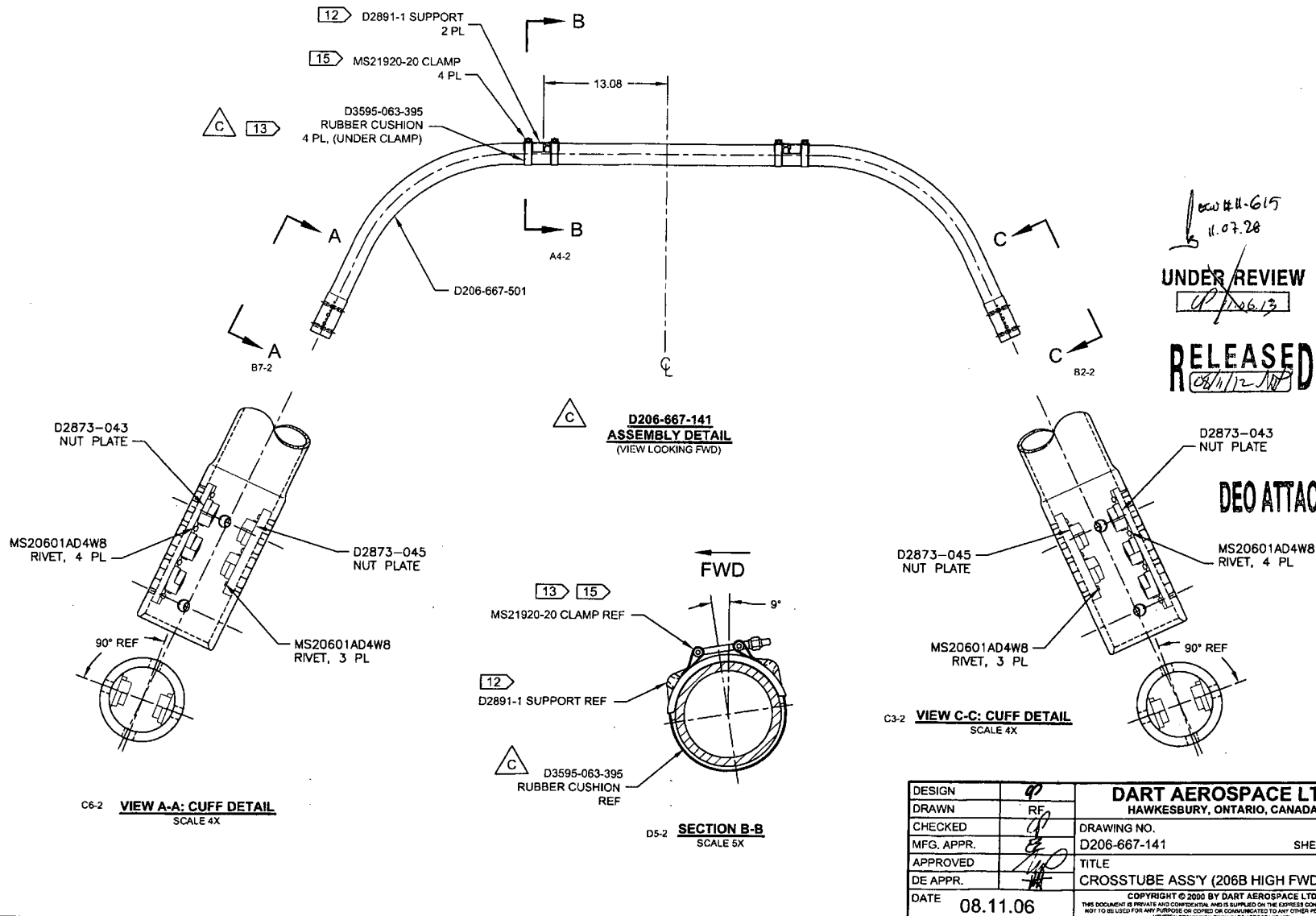
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NOTE: Date & initial all entries

80513



08/11/06
11.07.28
UNDER REVIEW
RELEASED
08/11/2006

DEO ATTACHED

Dart Aerospace Ltd

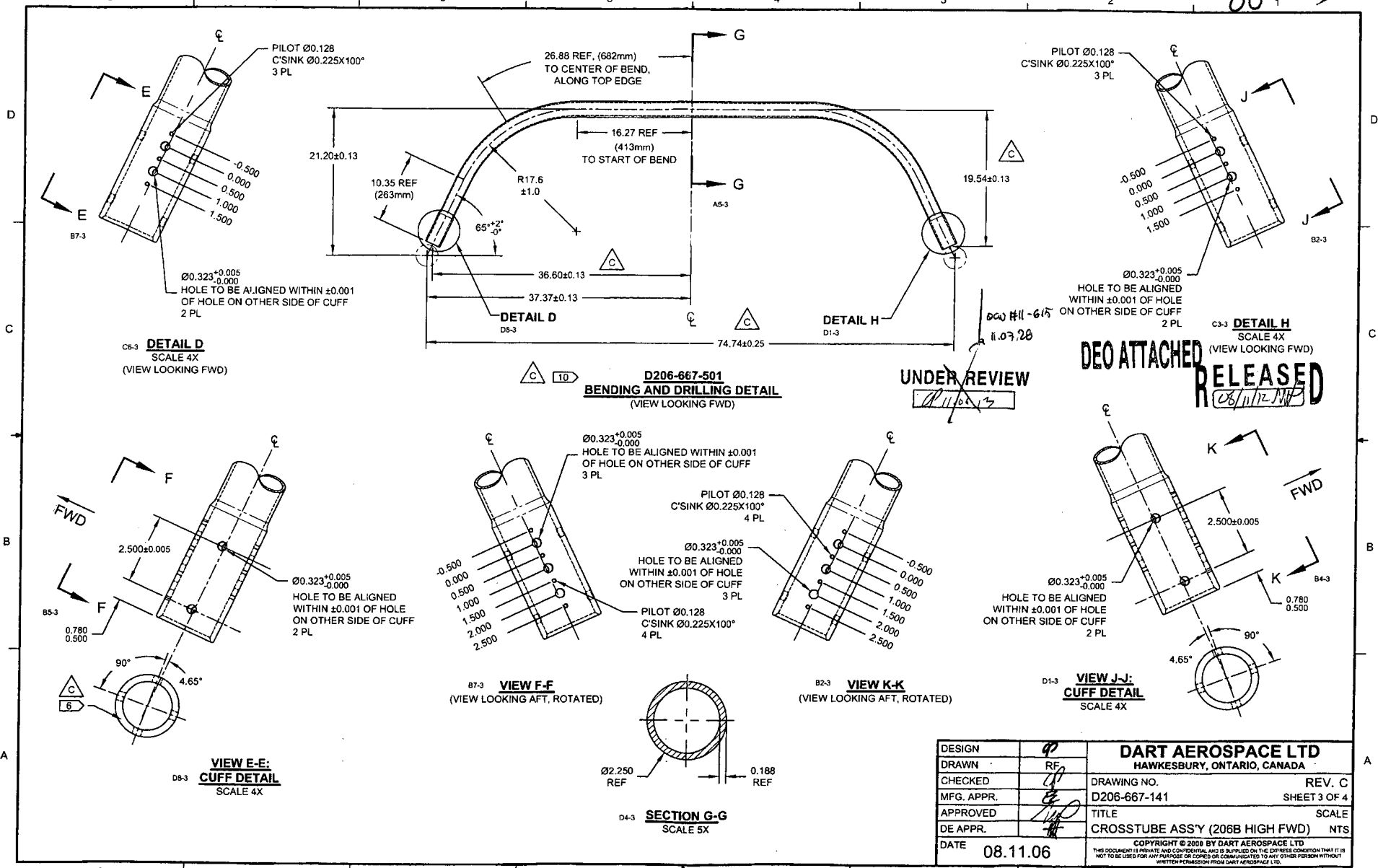
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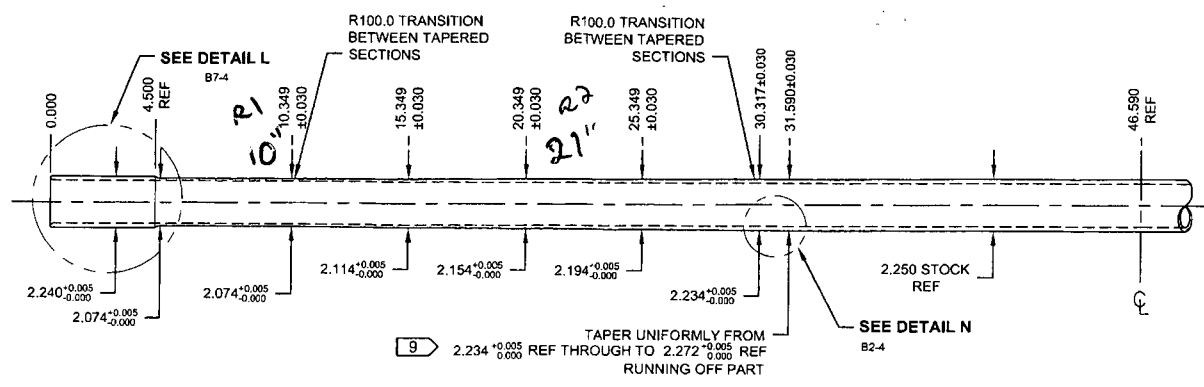
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

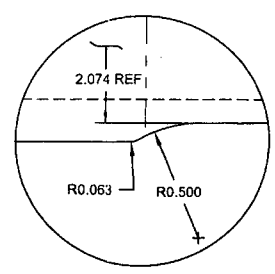
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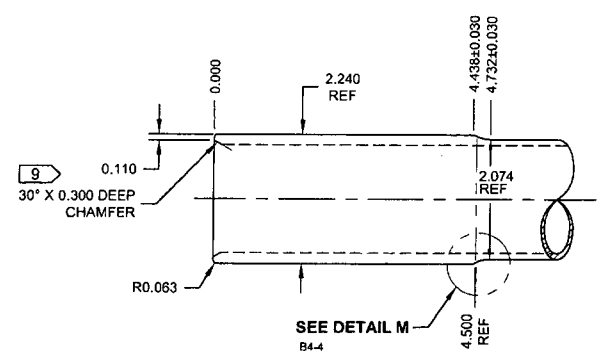
80513



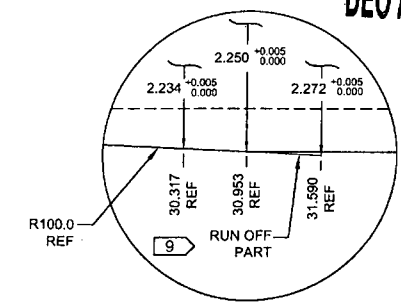
C TURNING DETAIL



A6-4 DETAIL M: CUFF TRANSITION NOT TO SCALE



D7-4 DETAIL L: CROSSTUBE CUFF NOT TO SCALE



C4-4 DETAIL N: TAPER RUN-OFF NOT TO SCALE

REV 11.09.28
11.09.28

UNDER REVIEW

DEO ATTACHED

RELEASED
08/11/12

| | | | |
|--|----------|--|--------------|
| DESIGN | 40 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 40 | DRAWING NO. | REV. C |
| MFG. APPR. | 40 | D206-667-141 | SHEET 4 OF 4 |
| APPROVED | 40 | TITLE | SCALE |
| DE APPR. | 40 | CROSSTUBE ASSY (206B HIGH FWD) | NTS |
| DATE | 08.11.06 | COPYRIGHT © 2000 BY DART AEROSPACE LTD | |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

side A

| | |
|---------|---------|
| 21 | 12 |
| 1- .111 | 1- .150 |
| 2- .113 | 2- .151 |
| 3- .109 | 3- .148 |
| 4- .165 | 4- .155 |

side B

| | |
|---------|---------|
| 21 | 12 |
| 1- .104 | 1- .142 |
| 2- .110 | 2- .150 |
| 3- .112 | 3- .152 |
| 4- .103 | 4- .142 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

80573

| | | | | | | | |
|-----------------------------|--|---------------------------|---|--|--------------------------------|---------------------------|--------------|
| DRAWING NO. D206-667-141 | TITLE CROSSTUBE ASS'Y (206B HIGH FWD) | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D206-667-141-C-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN 97 | CHECKED ASS | MFG. APPR. [Signature] | APPROVED [Signature] | | DE APPR. [Signature] | | |
| DATE 11.07.15 | DATE 11.07.20 | DATE 11.07.21 | DATE 11/07/21 | | DATE 11.07.21 | | |

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

| Item | Qty -141 | Part Number | Description |
|------|-------------|-----------------|-------------------------------|
| 9 | A/R | PROSEAL 890 B-2 | SEALANT, AMS-S-8802 CLASS B-2 |

WAS:

| | | | |
|---|-----|----------------|---|
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |
|---|-----|----------------|---|

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
[Signature]

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries